

split

Work Order ID 83936-1

83936

Page 1

Tuesday, May 29 2012 8:55:03 AM

Item ID: D3204-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 4/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-05-29

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

④

12-620.

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

12.06.22 ④

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

4

11/12/06 22

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

4

11/12/06 25

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

Cover holes for bushing

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50
320
12:20

H. 4

11/12/06 26

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

4 x 6 1/2 10/6/20

160

Small Fab

0.00

160

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

12

2/17/04

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

5/2/07/05

11

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Quality Control

Qty	Qty	Number	Stamp
12			
OK		12/7/9	
		mf	
		12-07-05	

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Picklist Print

Tuesday, May 29, 2012 8:55:02 AM

Page 1

Work Order ID: 83936

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/27/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11 Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 Tube		Manufactured	No			100	Each	4.0000	1	4		12-6-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		4				4			
				79294		4				4			
D3204-11 Plate		Manufactured	No			100	Each	8.0000	1	4		12-6-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		8				4			
				57522		8				4			
D3204-13 Gusset		Manufactured	No			100	Each	14.0000	2	8		12-6-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		14				8			
				70315		3				8			
				73465		11				8			
D3204-3 Arm		Manufactured	No			100	Each	13.0000	1	4		12-6-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		13				4			
				79801		13				4			
D3204-5 Arm		Manufactured	No			100	Each	4.0000	1	4		12-6-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		4				4			
				79294		4				4			

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Page 2

Work Order ID: 83936

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/27/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

D3204-9
Pedal

Manufactured	No	100	Each	7.0000	1
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EL 12-6-20

Location

Loc Qty

Loc Code

WA020

7

79803

7

D3204-7
Bushing

Manufactured	No	160	Each	7.0000	2
--------------	----	-----	------	--------	---

Location

Loc Qty

Loc Code

GA

7

77091

1

79802

6

4
12/07/04
385981
20

Tuesday, May 29, 2012 8:55:02 AM

Shop Packet Print

Page 2

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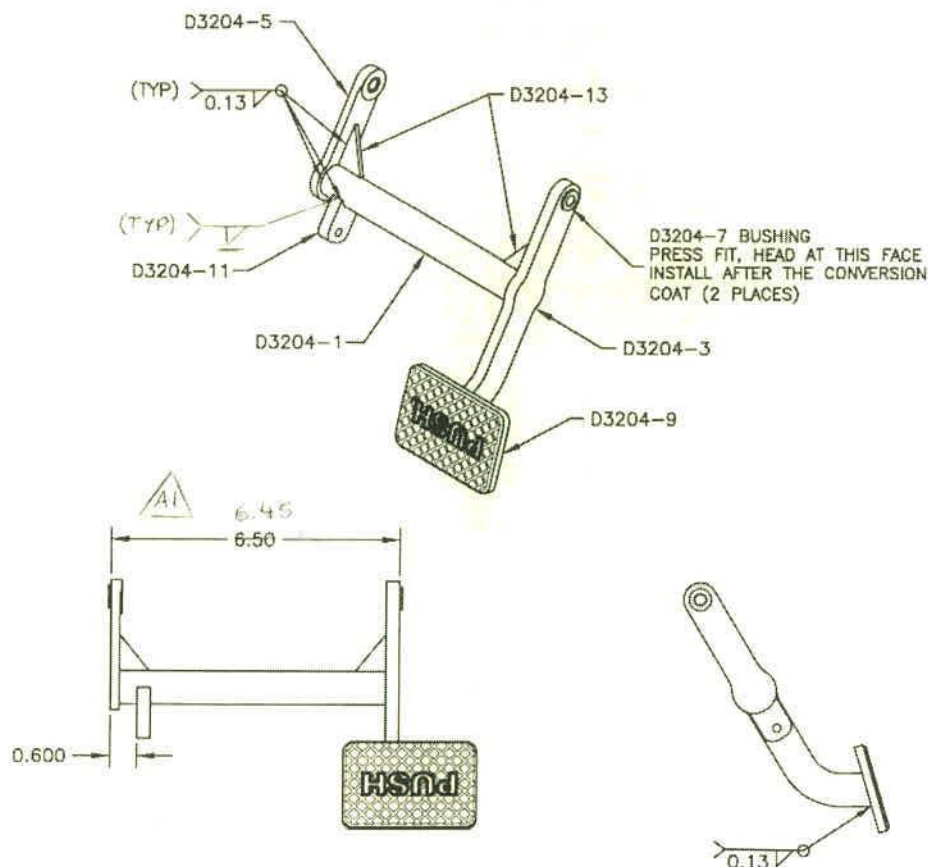
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
#0430 #



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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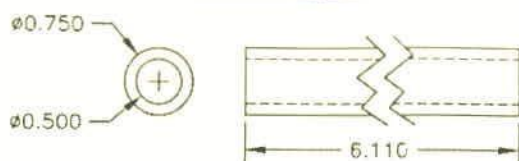
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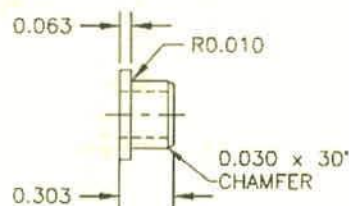


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

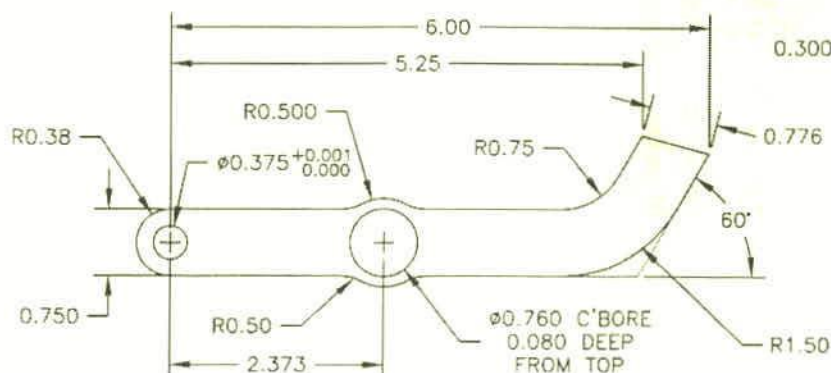
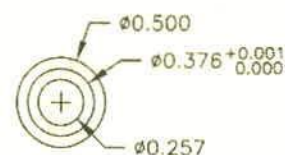
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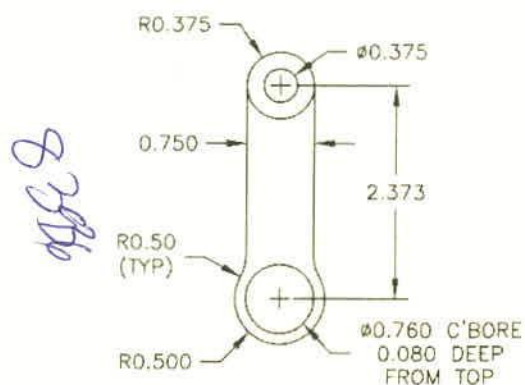
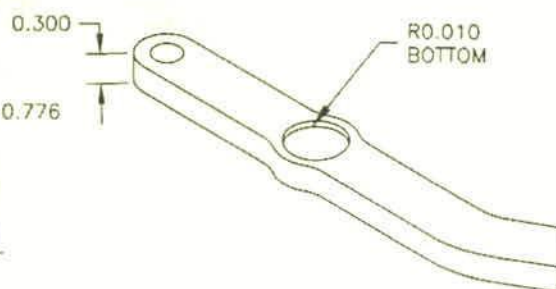
2 D3204-1 TUBE
SCALE 1:2



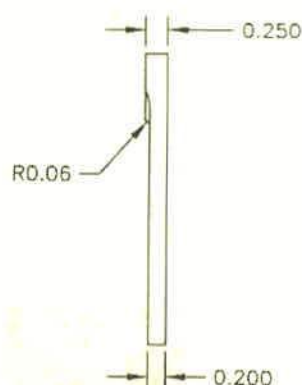
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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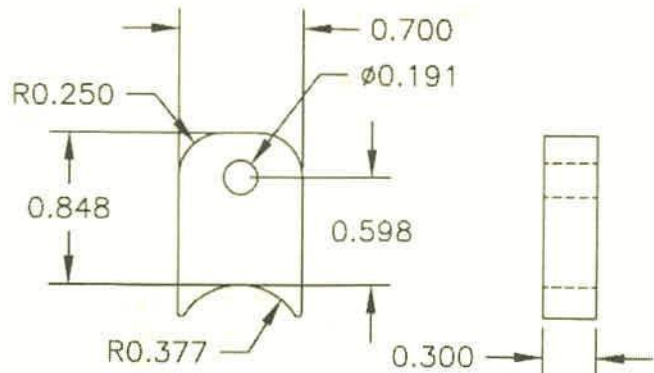
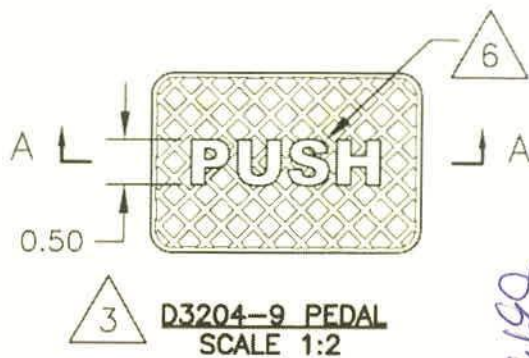
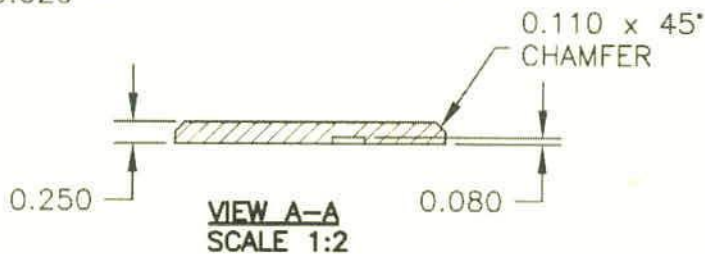
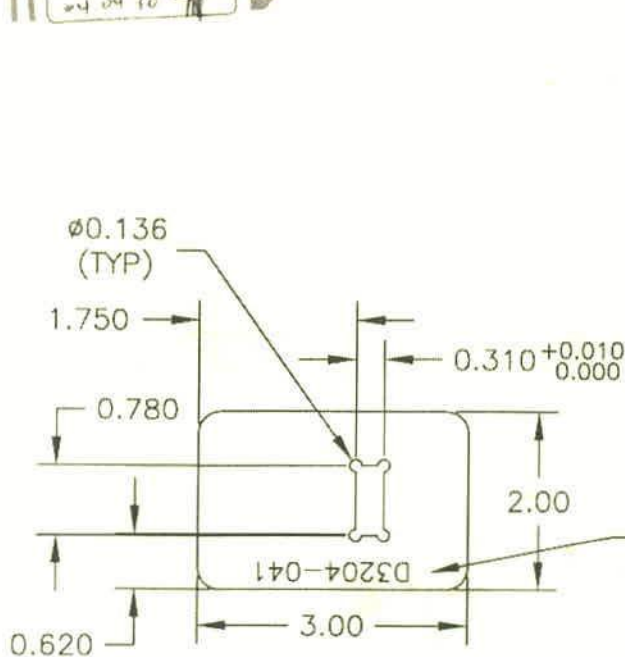
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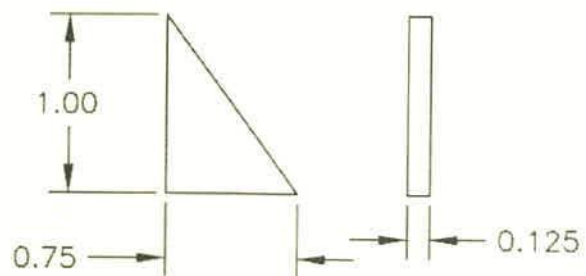
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04 04 70 [Signature]

D3204-11 PLATE
SCALE 1:1



D3204-13 GUSSET
SCALE 1:1

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